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⑬ **Quaternary ammonium salts of anionic gums.**

⑭ Derivatized anionic gums and compositions thereof are disclosed. The gum derivatives are prepared by reacting non-derivatized gum with quaternary ammonium compounds in an amount equal to or greater than the stoichiometric amount required for complete derivatization. The derived gums are soluble in organic solvents.

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QUATERNARY AMMONIUM SALTS OF ANIONIC GUMS

BACKGROUND OF THE INVENTION

5 U.S. Patent 3,163,602 teaches fully derivatized xanthan gum prepared by reacting xanthan gum aqueous solutions (either fermentation broth or solutions from dry powder) with an excess amount of quaternary ammonium compounds. The derivatized gum is insoluble in distilled water but soluble in brine.

10 SUMMARY OF THE INVENTION

Derivatized anionic gums have now been found which are produced by reacting an anionic gum with a quaternary ammonium compound in an amount equal to or in excess of the stoichiometric amount
15 necessary for complete derivatization of the gum. The derivatized gums are soluble in organic solvents.

An embodiment of this invention is quaternarized S-194 and quaternarized S-130.

Another embodiment is thickened compositions comprising a quaternarized anionic gum salt, an organic solvent, and, optionally, water.

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DETAILED DESCRIPTION

The anionic gums useful for preparing the derivatized quaternary ammonium salts of this invention are
25 xanthan, S-194, and S-130.

By the term "xanthan gum", as used herein, is meant the extracellularly produced gum made by the heteropolysaccharide-producing bacterium *Xanthomonas campestris* by the whole culture fermentation under a variety of conditions of a medium comprising: a fermentable carbohydrate, a nitrogen source, and other appropriate nutrients. Examples *inter alia*, of commercially available xanthan gums are KELTROL®
30 and KELZAN®, available from Kelco Division of Merck & Co., Inc.

Processes for producing xanthan gum are well-known in the art, e.g., U.S. Patent Nos. 4,316,012; 4,352,882; 4,375,512; 3,671,398; 3,433,708; 3,271,267; 3,594,280; 3,591,578; 3,391,061; 3,020,206; 3,481,889; 3,391,060; and UK 1,448,645.

By the term "S-194": (also known as rhamnan gum) is meant the extracellularly produced gum made
35 by the heteropolysaccharide-producing bacterium of the genus *Alcaligenes*, ATCC 31961, by the whole culture fermentation under a variety of conditions of a medium comprising: a fermentable carbohydrate, a nitrogen source, and other appropriate nutrients. Processes for producing S-194 are described in U.S.P. 4,401,760 and EP 192,332 (August 27, 1986), both of which are incorporated herein by reference.

By the term "S-130" (also known as welan gum) is meant the extracellularly produced gum made by
40 the heteropolysaccharide-producing bacterium of the genus *Alcaligenes*, ATCC 31555, by the whole culture fermentation under a variety of conditions of a medium comprising: a fermentable carbohydrate, a nitrogen source, and other appropriate nutrients. Processes for producing S-130 are described in U.S.P. 4,342,866, which is incorporated herein by reference.

The quaternary ammonium compounds (quats) useful in this invention are those having a single alkyl or
45 alkenyl substituent containing from about 13 to 24 carbon atoms, or two alkyl or alkenyl substituents of 12 to 24 carbons per substituent and the ethylene oxide substituted analogs thereof. These are known compounds. An especially useful quat is alkyl dimethylbenzylammonium chloride.

The derivatized anionic gum salts of this invention are readily formed by intimately mixing the non-derivatized anionic gums and the quats, preferably in an aqueous solution, slurry, or suspension. Generally,
50 this is done under mild conditions such as room temperature and neutral pH. However, temperatures can range from about 10° to 90°C and pH 2-8. The gum solution may be the fermentation broth in which the gum was produced. However, the reaction is preferably run using recovered gum in deionized water. The quat may be dissolved in either water or an alkanol/water blend. Normally, the amount of quat is in excess (up to about 3x) the stoichiometric amount required. Although tap water may be used it is preferable that there be no added soluble salts as such salts tend to screen anionic functional groups and thus tend to

prevent the gum/quat reaction. Following precipitation of the fibrous gum salts, they can be washed in hot water, dried and milled.

The salts of this invention are useful for viscosifying organic solvents, especially lower (C₁-C₃) alkanols, both straight and branched chain. These include methanol, ethanol, propanol, and isopropanol (IPA). Other useful solvents are N-methyl-2-pyrrolidone, ethylene glycol, and propylene glycol. Other than methanol, the alkanol solvents require 10-20% water (wt/wt) as co-solvent. In addition to the alkanols, these thickened compositions may also contain methylene chloride.

Generally, the compositions of this invention comprise 0.05 - 5.0% (wt/wt) (preferably 0.1 to 2%) derivatized gum and solvent, said solvent being N-methyl-2-pyrrolidone, C₁-C₃ alkanol, 9:1 to 8:2 C₁-C₃ alkanol:water, ethylene glycol, or propylene glycol. When the first solvent is methanol or methanol:water, the compositions may also comprise methylene chloride in amounts up of 60-80%, based on total weight of the composition.

Depending on the particular end use of these compositions, they may also contain additional ingredients. For example, compositions of this invention, when they comprise N-methyl-2-pyrrolidone or methylene chloride, are particularly useful as paint strippers. These paint stripping compositions may optionally contain paraffin wax to retard solvent evaporation, activators such as amines, and cationic or anionic surfactants to promote removal by water. Such additives are well known to formulators of paint stripping compositions.

The solvent N-methyl-2-pyrrolidone (NMP) can be used as a replacement for methylene chloride in paint strippers. The solvent can be used as is or blended with water and is effective in removing dried paint films. It was discovered that many of the derivatized anionic gum salts of this invention are soluble in NMP or NMP/water blends and provide high viscosity particularly at low shear rates, which permits the stripper to cling to vertical surfaces but does not interfere with its effectiveness.

The derivatized gums may also be used in alkanol based foams. Cremaet *al.*, Soc. of Pet. Eng. No. 13565, 159-161 (1985) discuss the foaming of anhydrous methanol for well stimulation. Such foams contain nonionic and fluoro-surfactants as foaming agents and may contain stabilizers to increase half-life provided they do not detract from foam quality, which is basically a percentage increase in volume due to foaming.

Other compositions include alkanol based coal slurries for stable fuel or for transport of coal, cosmetic films, thickened fuels (e.g., charcoal starters, Sterno-type fuels, etc.) de-icing fluids, alcohol-based printing inks, ceramic binders, and similar systems where it is desirable to viscosify or suspend organic solvent-based systems.

Since these quaternary ammonium salts retain the high viscosity and pseudoplastic rheology of the native, i.e. non-derivatized, gums, they advantageously permit the application of organic solvents to, for example, vertical surfaces without excessive sagging or run-off and provide suspension stability over time.

Furthermore, the shear-thinning characteristics of these salts permit easy pumping of these compositions. In de-icing compositions for application to aircraft, this combination of properties is very advantageous.

Other embodiment of this invention is a composition useful for preparing flexible bactericidal films. Such films may be cast directly from compositions comprising 0.1-2% quaternary ammonium salt and propylene glycol or C₂-C₃ alkanol/water solutions wherein the ratio alkanol:water is approximately 1.5:1. Where extra mildness is desired a quat with a low primary irritation index (such as Monaquat P-TC) may be used.

The invention is further defined by reference to the following examples, which are intended to be illustrative and not limiting.

Temperatures are in degrees Celsius.

Chemically, the quats used in the following examples are as follows:

- 1) Ethoquad 18/12 - methylbis(2-hydroxyethyl)octadecyl NH₄Cl, 70% active;
- 2) Arquad 2C-75 - dicocodimethyl ammonium chloride, 75% active;
- 3) Arquad 12-50 - dodecyltrimethyl NH₄Cl, 50% active;
- 4) Arquad 16-50 - hexadecyltrimethyl NH₄Cl, 50% active;
- 5) Arquad 18-50 - octadecyltrimethyl ammonium chloride, 50% active;
- 6) Arquad 2HT-75 - dimethyldi(hydrogenated tallow) NH₄Cl, 75% active;
- 7) Barquat MS-100 - stearyldimethyl benzyl NH₄Cl, 100% active;
- 8) Ethoquad 18/25 - methylpolyoxyethylene (15) octadecyl NH₄Cl, 95% active;
- 9) Jordaquat 522 - Isostearyl amido propyldimethylethyl ammonium ethosulfate, 85% active;
- 10) Jordaquat 1033 - soyadimethylethyl ammonium ethosulfate, 54% active; and
- 11) Adogen 442 - Di(hydrogenated tallow) dimethyl NH₄Cl, 75% active.
- 12) Monaquat P-TC - tri(cocamidopropyldimethylpropylene glycol ammonium chloride) phosphate.

EXAMPLE 1DERIVATIZED ANIONIC GUMS

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60 ml of a 1.5% (wt.) gum solution in deionized water was reacted at 25°C by mixing with a mechanical stirrer for up to 1/2 hour with twice the stoichiometric amount of the following quats:

- 10 1) Arquad 12/50
2) Arquad 18/50
3) Arquad 16/50
4) Arquad 2C-75
5) Ethoquad 18/25
6) Ethoquad 18/12
15 7) Barquat MS-100
8) Jordaquat 522
9) Jordaquat 1033

The fibrous precipitates were washed with hot water, dried, and milled through 80 mesh (U.S. Standard). All the derivatives were soluble in methanol. Solubility in ethanol or isopropanol required the
20 addition of 10-20% water (wt/wt) as co-solvent.

The viscosities of the salts in ethanol are usually less than obtained with the non-derivatized gum in water; however the pseudoplastic or shear thinning behavior is retained and the low shear rate viscosities remain high for good suspending ability. The following viscosities were obtained on 1.0% (wt.) solutions in methanol (after 3 hours of mixing) using a Brookfield LVT viscometer, spindle #2, 25°C.

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	<u>Gum</u>	<u>Quat</u>	60 rpm Visc.	6 rpm Visc.
			<u>(cP)</u>	<u>(cP)</u>
30	1) Xanthan	Arquad 18-50	530	2300
35	2) "	Jordaquat 1033	290	800
	3) "	Jordaquat 522	305	1300
40	4) Rhamsan	Arquad 16-50	410	3000
	5) "	Jordaquat 1033	510	4100
45	6) "	Barquat MS-100	600	4500

50 EXAMPLE 2

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METHYLENE CHLORIDE COMPOSITIONS

The derivatives of Example 1 are not soluble in neat methylene chloride but are soluble when about 20% methanol is present to solvate the polymer. (The derivative may be dissolved in methanol first then added to methylene chloride or, depending on the quat, may be dissolved directly in a methylene chloride/methanol blend.) The following derivatives dissolved directly in a methylene chloride:methanol 80/20 (w:w) blend at ambient temperature to produce viscous solutions.

<u>Gum</u>	<u>Quat</u>	60 rpm Visc.	6 rpm Visc.
		<u>(cP)</u>	<u>(cP)</u>
1) Xanthan	Arquad 16-50	1200	6500
2) Xanthan	Arquad 2HT-75	1550	7500
3) Rhamsan	Ethoquad 18/25	600	4000

PAINT STRIPPER

<u>Ingredient</u>	<u>% by Weight</u>
Paraffin wax	1.5
Tripropyl amine	1.5
Xanthan gum/Arquad 18-50	1.0
Methylene chloride	76.8
Methanol	19.2

All liquids were blended, the wax was added, followed by the xanthan gum/quat derivative. The composition was placed in a closed Osterizer blender and sheared at medium speed while warming to dissolve the wax. The product was viscous, 1070 cP (Brookfield LVT viscometer, spindle #3 at 60 rpm) and stable for six months at ambient temperature with no liquid separation. When applied to painted surface, both wood and metal, the paint was lifted by the solvent and could be scraped off easily.

EXAMPLE 3FOAMS

Using the procedure for making foams recommended by Crema *et al.*, *supra*, 200 ml methanol containing 0.5% FC-742 (fluorocarbon surfactant, 3M) and 2% Pluradyne SF-1042 (BASF) were placed in a Hobart mixer and mixed five minutes at 300 rpm with a wire whip. The foam quality and half-life (time to break foam to 100 ml of free liquid) were measured. The xanthan gum and rhamsan gum derivatives were first dissolved in the methanol followed by the surfactants. The following data were obtained:

<u>Stabilizer</u>	<u>Foam Quality</u>	<u>Half-Life</u>	<u>Viscosity*</u>
1) Control	81.5	2.75 min	3.0 cP
2) Xanthan gum/ Arquad 16-50 deriv. (0.05%)	76.7	8.75 min	6.4 cP
3) Rhamsan gum Jordaquat 1033 (0.05%)	69.0	6.25 min	6.8 cP

* Brookfield LVT viscometer, spindle #1, 60 rpm.

The quat derivatives increased the half-life by increasing the viscosity without seriously affecting the foam quality, and thus are useful for stabilizing alkanol foams.

EXAMPLE 4

N-METHYL-2-PYRROLIDONE COMPOSITIONS

Following a procedure such as in Example 1, quaternary ammonium salts of xanthan, rhamsan, and welan gums were prepared and NMP compositions containing 1% salt and 99% NMP were prepared by dissolving the salt derivatives directly in the NMP. Viscosities of these compositions were measured on a Brookfield LVT viscometer, spindle #3 and the following data obtained:

<u>Gum</u>	<u>Quat</u>	<u>60 rpm Visc. (cP)</u>	<u>6 rpm Visc. (cP)</u>
Xanthan	Arquad 12-50	1500	3700
"	Adogen 442	416	2500
"	Barquat MS-100	310	610
"	Arquad 2C-75	440	1000
Rhamsan (S-194)	Adogen 442	410	2500
Welan (S-130)	Arquad MS-100	670	1200

EXAMPLE 5

BACTERICIDAL FILMS

5 The gum derivatives of this invention form flexible films when cast from alcohol solutions. Such films are valuable as a slow release form of the quat to provide bactericidal activity. Alcohol/water blends containing greater than 50% isopropanol have been used as a disinfectant hand wash in hospitals. The derivatives of this invention are soluble directly in 60% isopropanol/40% water (1.5:1) solutions and provide a lotion type feel on the skin.

10 Xanthan gum precipitated with Monaquat P-TC (as in Example 1) dissolved directly in 60% isopropanol while the control (unreacted) xanthan gum did not. The xanthan derivative produced a viscosity of 600 cp at 60 rpm and 3400 cp at 6 rpm in 60% isopropanol when measured on a Brookfield LVT Viscometer using spindle #3.

15 **Claims**

1. A fully derivatized quaternary ammonium salt of an anionic gum, which is S-194 or S-130.
2. A salt of Claim 1 wherein the quaternary ammonium compound contains a single alkyl or alkenyl substituent of 13-24 carbon atoms or two alkyl or alkenyl substituents of 12-24 carbon atoms per
20 substituents, and the ethylene oxide substituted analogs thereof.
3. A salt of Claim 2 wherein the gum is S-194.
4. A salt of Claim 2 wherein the gum is S-130.
5. A viscous organic solvent composition comprising by weight:
 - a) 0.05-5.0% quaternary ammonium salt of xanthan gum, S-194, or S-130; and
 - 25 b) a solvent which is one C₁-C₃ alkanol, N-methyl-2-pyrrolidone, ethylene glycol, or propylene glycol with the proviso that when the solvent is an alkanol other than methanol the solvent contains 10-20% water.
6. A composition of Claim 5 comprising 60-80% methylene chloride and a solvent which is methanol or a methanol/water solution.
7. A composition of Claim 5 comprising 0.1 - 2% salt and the solvent propylene glycol or C₂-C₃/water
30 solution wherein the ratio alkanol/water is approximately 1.5:1.
8. A composition of Claim 7 wherein the quaternary ammonium compound is tri (cocamidopropyl)dimethylpropyleneglycol ammonium chloride) phosphate.

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EUROPEAN SEARCH REPORT

Application Number

EP 88 30 3230

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
X	GB-A- 876 603 (NATIONAL LEAD CO.) * Page 1, line 60 - page 2, line 21; page 3, lines 60-82; claim 1 *	1,2,5	C 08 B 37/00 C 08 L 5/00 // C 09 D 9/00 C 09 K 7/00 A 61 K 7/48
X	US-A-2 931 753 (R.M. CHESBRO et al.) * Column 4, lines 51-69; claims 1,2,15 *	1,2,5	
D,A	US-A-3 163 602 (G.P. LINDBLOM et al.) * Claims 1-3 *	1,2	
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			C 08 B C 08 L
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 24-08-1988	Examiner SOMERVILLE F.M.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- & : member of the same patent family, corresponding document	